

**Work Order ID 155070**

Friday, January 06, 2017 11:05:27 AM

*for flight test*  
**\*155070\***

Page 1

Item ID: D5351-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: T-Bolt Spacer

Start Date: 01/06/2017 Start Qty: 22.00

**\*22\***

Cust Item ID:

Required Date: 01/18/2017 Req'd Qty: 22.00

**\*22\***

Customer:

Reference:

Approvals:

Process Plan: 

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D5351    | A            |

100

0.00

**\*100\***

Doosan

Doosan Lathe

Memo

turn as per Dwg and folio FB451

Dwg Rev: AFOLIO REV: AA

Deburr

0.29

2417-01-09

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

Memo

0.04

2417-01-09

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Friday, January 06, 2017 11:05:27 AM

Item ID: D5351-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: T-Bolt Spacer  
Start Date: 01/06/2017 Start Qty: 22.00 **\*22\*** Cust Item ID:  
Required Date: 01/18/2017 Req'd Qty: 22.00 **\*22\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|     |                                   |      |  |  |  |  |  |  |  |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|
| 120 | QC8- Inspect parts - second check | 0.00 |  |  |  |  |  |  |  |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|

**\*120\***

QC

Quality Control

Memo

0.07

(24) 17.01.08

DAS  
9  
9-88

121

0.00

**\*121\***

Outsource4

Outsource process - Anodize

Memo

0.00

ANODIZE BLACK AS PER DWG D5351 NOTE 2

ISSUE P.O:

POSSIBLE SUPPLIER :ATG

C OF C IS REQUIRED

122

0.00

**\*122\***

Packaging

Packaging

Receive &amp; Inspect for Damage &amp; Mat'l Certs

Memo

0.00

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**\*155070\***

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Item ID: D5351-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: T-Bolt Spacer  
Start Date: 01/06/2017 Start Qty: 22.00 **\*22\*** Cust Item ID:  
Required Date: 01/18/2017 Req'd Qty: 22.00 **\*22\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

123

**\*123\***

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

130

**\*130\***

Packaging

Packaging

Identify as per dwg & Stock Location: ST-GA

0.00

Memo

0.04

LOCATION:

140

**\*140\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.37

24X Sp 17-01-9.DAS  
21  
9-89

JAN 10 2017

JAN 10 2017

DAS  
21  
9-89

# Picklist Print

Friday, January 06, 2017 11:05:26 AM

Page 1

Work Order ID: 155070

\*155070\*

Parent Item: D5351-1

\*D5351-1\*

Parent Item Name: T-Bolt Spacer

Start Date: 01/06/2017

Required Date: 01/18/2017

Start Qty: 22.00

Required Qty: 22.00

Comments: IPP REV:A NEW ISSUE 16-01-11 JLM VERIFIED BY:DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6R0.500                   |                        | Purchased     | No          |                     |                  |                 | f                  | 21.6760        |             | 1.929747     |               |                |        |
| *M6061T6R0.500*                 |                        |               |             |                     |                  |                 |                    |                | **          |              |               |                |        |
| 6061-T6 Round Bar .500"         |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

Location

Loc Qty

Loc Code

MAT012

21.676

M134776

4.979

M135377

8.557

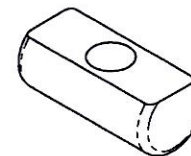
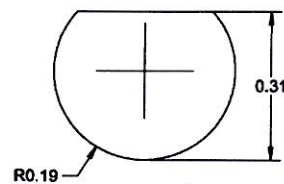
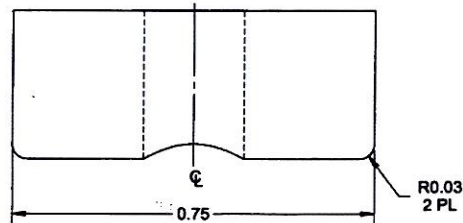
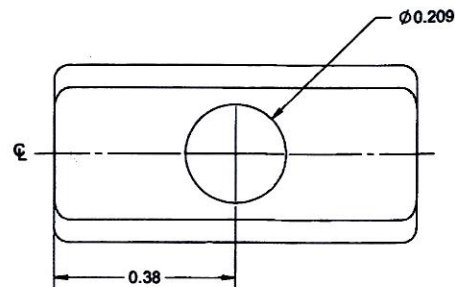
M136327

8.14

2'

17-01-09

24"



# **D5351-1 T-BOLT SPACER**

## **NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-Q-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF. DART SPEC M6061T6R
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.01 lbs

**RELEASED**  
2016-01-21  
ECA/16-504

**APPROVED**  
D

| A          |             | NEW ISSUE                                                                                                                                                                                                                                                                      | RF     | 15.08.10     |
|------------|-------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|--------------|
| REV.       | DESCRIPTION |                                                                                                                                                                                                                                                                                | BY     | DATE         |
| DESIGN     | RF          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                       |        |              |
| DRAWN      | RF          |                                                                                                                                                                                                                                                                                |        |              |
| CHECKED    | AK          | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. A |              |
| MFG. APPR. | JLM         | D5351                                                                                                                                                                                                                                                                          |        | SHEET 1 OF 1 |
| APPROVED   | HS          | TITLE                                                                                                                                                                                                                                                                          | SCALE  |              |
| DE APPR.   | DS          | T-BOLT SPACER                                                                                                                                                                                                                                                                  | NTS    |              |
| DATE       | 15.08.10    | COPYRIGHT © 2015 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |        |              |

4776-1



